

Work Order ID 74837

Tuesday, October 11, 2011 9:59:02 AM

74837

Ship Oct 21 st Page 1

Item ID: D350-794-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Tank Assembly

Stop ***NS2***

Start Date: 10/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MF Date: 11-10-11

Tooling:

Date:

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D350-794	C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-794-041

CHG003

5/10/12

For MLS 11-10-12

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

Rec'd 11/12

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

5/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74837***74837***

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Tuesday, October 11, 2011 9:59:02 AM

Item ID: D350-794-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tank Assembly

Start Date: 10/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

Packaging

Memo

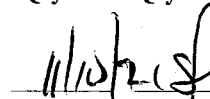
Identify and pack for shipping as per PPPD350-794-041

Location: 

PPP Rev: _____

0.00

0.00



140

140

QC

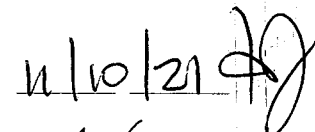
Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00



MK

11-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 11, 2011 9:59:02 AM

Page 1

Work Order ID: 74837

Parent Item: D350-794-041

Parent Item Name: Tank Assembly

Start Date: 10/11/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.05.17 ECN10-562 DD verf: list EC verified by: DD - IPP REV:C 11.09.27 AS PER CHG 003 DD VERF:EC IPP Rev B 10.11.18 updated pick

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN816-6D Nipple M-6 Flare -1/4NPT		Purchased	No			110	Each	15.0000	1	1	-		

Location	Loc Qty	Loc Code
ST330	15	
118378	5	
118529	10	

D4008-041 Fuel Filler Splash Guard Assembly		Manufactured	No			110	Each	2.0000	1	1	-		
--	--	--------------	----	--	--	-----	------	--------	---	---	---	--	--

Location	Loc Qty	Loc Code
ST108	2	
72200	2	

D4025-1 Fuel Quantity Sender		Manufactured	No			110	Each	7.0000	1	1	-		
---------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	---	--	--

Location	Loc Qty	Loc Code
ST141a	7	
71765	6	
72257	1	

D4055-041 Fuel Tank Assembly		Manufactured	No			110	Each	0.0000	1	1	-		
---------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	---	--	--

D4023-1 Cap and Flange		Manufactured	No			110	Each	8.0000	1	1	-		
---------------------------	--	--------------	----	--	--	-----	------	--------	---	---	---	--	--

Location	Loc Qty	Loc Code
ST110	6	
64879	6	
WA013	2	
66862	2	

118378

72200

72257

73262

66862

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 74837

Parent Item: D350-794-041

Parent Item Name: Tank Assembly

Start Date: 10/11/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

~~D4002-041~~

Aux Tank Drain Hose Assembly, Fwd

Manufactured No

110 Each 4.0000

~~1~~ 1

Location

Loc Qty

Loc Code

ST193

4

73558

2

73918

2

110 Each 4.0000

~~1~~ 1

~~D4002-043~~

Aux Tank Drain Hose Assembly, Aft

Manufactured No

Location

Loc Qty

Loc Code

ST193

4

73554

2

73919

2

110 Each 12.0000

~~2~~ 2

~~MS20822-3D~~

Elbow

Purchased No

Location

Loc Qty

Loc Code

ST299

12

118529

7

119109

5

110 Each 11.0000

~~1~~ 1

~~MS20822-8D~~

Elbow-90M-1/2Flare-3/8NP

Purchased No

Location

Loc Qty

Loc Code

ST299

11

116583

1

118529

10

110 Each 7.0000

~~2~~ 2

~~D4009-041~~

Bonding Braid

Manufactured No

Location

Loc Qty

Loc Code

ST109

7

72443

1

74046

6

110 Each 0.0000

~~3~~ 3

~~TBA28B~~

Cable Tie Fastener

Purchased No

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 11, 2011 9:59:02 AM

Page 3

Work Order ID: 74837

Parent Item: D350-794-041

Parent Item Name: Tank Assembly

Start Date: 10/11/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

UY25MX

Tie Wrap

Purchased

No

110

Each

894.0000

1

1

Location

Loc Qty

Loc Code

ST380

894

115695

894

115695

10/11/11

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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4.0 ELECTRICAL LOAD

The electrical load effect for each aircraft must be assessed as follows.

Component	Load
Fuel Pump	3.00 Amps
Fuel Gauge	0.45 Amps
Fuel Sender	0.13 Amps
Total Installation	3.58 Amps = 100 Watts

5.0 WEIGHT AND BALANCE

The following is the weight increase associated with the Aux Fuel Tank Installation. Be sure to subtract the weight of any parts or material removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-794-011 Auxiliary Fuel Tank (AS350 models)	29.8 lb 13.5 kg	-22.0 in -0.56 m	-655.6 in-lb -7.56 m-kG	126.0 in 3.20 m	3754.8 in-lb 43.2 m-kG
D350-794-013 Auxiliary Fuel Tank Provisions (AS350 models)	5.5 lb 2.5 kg	-14.6 in -0.37 m	-80.3 in-lb -0.93 m-kG	163.4 in 4.15 m	898.7 in-lb 10.4 m-kG
D130-794-021 Auxiliary Fuel Tank (EC130 models)	29.8 lb 13.5 kg	-23.6 in -0.60 m	-703.3 in-lb -8.1 m-kG	126.0 in 3.20 m	3754.8 in-lb 43.2 m-kG
D130-794-023 Auxiliary Fuel Tank Provisions (EC130 models)	5.5 lb 2.5 kg	-16.1 in -0.41 m	-88.6 in-lb -1.03 m-kG	163.4 in 4.15 m	898.7 in-lb 10.4 m-kG

6.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Part Number	Superseded Part Numbers	Description
X					D350-794-011		AUXILIARY FUEL TANK (AS 350 SERIES)
1	X				D350-794-013		AUXILIARY FUEL TANK PROVISIONS (AS 350 SERIES)
		X			D130-794-021		AUXILIARY FUEL TANK (EC 130 SERIES)
		1	X		D130-794-023		AUXILIARY FUEL TANK PROVISIONS (EC 130 SERIES)
1		1		X	D350-794-041		TANK ASSEMBLY
				1	D4055-041	JCA/M47-1-01A	FUEL TANK
	1		1		D4022-041	A8150-B1-JCA	FUEL TRANSFER PUMP ASSEMBLY
				1	D4023-1	ER281	FUEL CAP
	1		1		D4002-5	JCA-M47-2-13	SUPPLY HOSE - FROM AUX TANK
	1		1		D4003-047	JCA-M47-2-16	FUEL PUMP INLET PIPE
	1		1		D4002-7	JCA-M47-2-25	SUPPLY HOSE - PUMP TO MAIN TANK FILLER NECK
				1	D4002-041	JCA-M47-1-13	DRAIN HOSE ASSEMBLY - FRONT
				1	D4002-043	JCA-M47-1-16	DRAIN HOSE ASSEMBLY - REAR
				2	MS20822-3D		UNION
	1		1		AN832-6D		BULKHEAD UNION
				1	AN816-6D		STRAIGHT FITTING
	2		2		AN924-6D		NUT (ALTERNATE AS5178D06)
	2		2		NAS1149D0963J		WASHER

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Part Number	Superseded Part Numbers	Description
				1	MS20822-8D		90° FITTING
	2		2		AN815-6D		UNION
	2		2		MS29512-06		ORING
	1		1		D4022-3	05-00021	FUEL PUMP MOUNTING BRACKET
	2		2		AN3-4A		BOLT
	2		2		MS21042-3		NUT
	2		2		AN970-3		WASHER
	1		1		D4008-043	JCA-M47-2-29	FUEL PUMP SPLASH GUARD
	1		1		D4004-7	N3	HOSE CLIP
				2	D4009-041	JCA-M47-4-01	BONDING BRAID
				1	D4008-041	JCA-M47-2-26	AUXILIARY TANK FILLER SPLASH GUARD
	4		4		AN525-10R6		SCREW
	1		1		D4001-3	AN832-6D-JCA	BULKHEAD FITTING - MODIFIED
	7		7		CR3212-5-5		CHERRY MAX RIVET
	18		18		CR3213-4-3		CHERRY MAX RIVET
	4		4		CR3212-4-3		CHERRY MAX RIVET
	12		12		MS20470AD4-6		RIVET
	32		32		MS20470AD3-4		RIVET
	16		16		MS20470AD5-6		RIVET
	6		6		MS20470AD5-8		RIVET
	9		9		CR3213-5-2		CHERRY MAX RIVET
	6		6		CR3212-5-4		CHERRY MAX RIVET
	3		3		CR3212-5-3		CHERRY MAX RIVET
	10		10		CR3212-5-2		CHERRY MAX RIVET
							Vent Assembly Parts
	2		2		MS21919WDG-8		CLAMP
	1		1		D4003-11	JCA-M47-2-21	VENT PIPE - TANK
			1		D4027-041	JCA-M47-2-20	VENT CLAMP ASSEMBLY
	1		1		D4003-049	JCA-M47-2-17	VENT PIPE - TANK
	1		1		D4027-043	JCA-M47-2-35	VENT CLAMP ASSEMBLY
	1		1		D4063-3	193-8	VENT HOSE
	2		2		2000-8S		HOSE CLAMP
	1		1		NAS43DD3-32N		SPACER
	1		1		MS35207-267		SCREW
	2		2		MS35207-264		SCREW
	3		3		NAS1149D0332J		WASHER
	3		3		MS21042-3		NUT
				3	TBA28B		CABLE TIE FASTENER
				1	TY25MX		TIE WRAP
	1		1		MS21919WDG-6		CLAMP (RUBBER REMOVED)
	1		1		D4009-041	JCA-M47-4-01	BONDING BRAID ASSEMBLY
							Restraint Assembly Parts
	1		1		D4005-1	JCA-M47-2-03	REAR RESTRAINT ANGLE/GUTTER
	1		1		D4004-11	JCA-M47-2-11	TOP STRAP ATTACH BRACKET
	1		1		D4004-5	JCA-M47-2-23	BOTTOM STRAP ATTACH BRACKET
	3		3		MS24694-S50		SCREW
	3		3		MS21042-3		NUT
	3		3		NAS1149F0363P		WASHER
	1		1		D4024-041	JCA/ASSO/MIN	ANCRA RESTRAINT STRAP
	1		1		D4004-041	JCA-M47-2-19	SIDE RESTRAINT ANGLE
	1		1		D4007-3	JCA-M47-2-18	TOP SUPPORT BRACKET
	1		1		D4006-041	JCA-M47-2-01	TANK TOP SUPPORT ASSEMBLY

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Part Number	Superseded Part Numbers	Description
	2		2		AN4-5A		BOLT
	2		2		NAS1149F0463P		WASHER
							Locker Preparation Parts
	1		1		D4005-041	JCA-M47-2-22	FORWARD FLOOR GUTTER
	1		1		D4063-1	193-6	DRAIN HOSE
	1		1		MS21919WDG-9		CLAMP
	1		1		MS35207-264		SCREW
	1		1		NAS1149D0332J		WASHER
	1		1		MS21042-3		NUT
	1		1		2000-6S		HOSE CLAMP
	3		3		NAS1474-08		SEALED CAPTIVE ANCHOR NUT
	1		1		D4005-11	JCA-M47-2-12	FINISHING STRIP
	4		4		MS21059-L08		ANCHOR NUT
	7		7		AN525-832R6		SCREW
							Electrical Parts
	1		1		D8-603		6.3A ECF FUSE (ALTERNATE HA23-6U3)
	1		1		D1-205		2.5A ECF FUSE (ALTERNATE HA21-2U5)
	1		1		MS35058-23		SWITCH
	1		1		107-964		CONNECTOR RECEPTACLE
	1		1		107-978		CONNECTOR BACKSHELL (ALTERNATE 105-5465)
	1		1		107-943		CONNECTOR PLUG
				1	D4025-1	VDO-M47-JCA	FUEL QUANTITY SENDER
	4		4		MS35206-217		SCREW
	4		4		NAS1149FN416P		WASHER
	4		4		MS21044N04		NUT
	1		1		143-207		PLUG
	1		1		143-208		RECEPTACLE
	1		1		143-204		RECEPTACLE HOUSING (ALTERNATE 973-1490)
	1		1		143-203		PLUG HOUSING (ALTERNATE 973-1482)
	5		5		143-219		CRIMP PIN (ALTERNATE 977-3800)
	5		5		143-217		CRIMP SOCKET (ALTERNATE 977-3797)
	1		1		D4009-041	JCA-M47-4-01	BONDING BRAID ASSEMBLY
	1		1		D4026-041	FL-100-R-JCA	FUEL GAUGE
	2		2		AN525-832R6		SCREW - GROUND STUD
	2		2		NAS1149FN832P		WASHER
	2		2		MS21042-08		NUT
	1		1		444-2556		GAUGE MASTER SWITCH
	1		1		D4022-5	3775628	THERMAL SWITCH (125°) - FARNELL (ALTERNATE 100-6847)
							General
	1		1		AN5800-1		PLACARD HOLDER
	1		1		AN929-6D		BLANK CAP
							Additional EC 130 Parts
			3		MS35207-264		SCREW
			3		NAS1149D0332J		WASHER
			3		MS21042-3		NUT
			1		D4027-041	JCA-M47-2-20	VENT CLAMP ASSEMBLY
			1		D4004-043	JCA-M47-2-04	SIDE RESTRAINT ANGLE AND TIE DOWN POINT

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Revision: C

Date: 10.01.25

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Part Number	Superseded Part Numbers	Description
			1		D4005-5	JCA-M47-2-06	ANGLE
			4		D4005-7	JCA-M47-2-07	ANGLE
			1		D4005-9	JCA-M47-2-08	ANGLE
			1		D4007-1	JCA-M47-2-02	TOP SUPPORT BRACKET
			1		D4005-3	JCA-M47-2-05	FORWARD RESTRAINT BEAM
			2		AN4-6A		BOLT
			1		D4007-5	JCA-M47-2-24	PACKER
			60		MS20470AD4-4		RIVET
			30		MS20470AD4-6		RIVET
			10		CR3213-4-3		CHERRY MAX RIVET
			10		CR3213-4-2		CHERRY MAX RIVET
							Placards
	1				D3997-1	JCA-M47-P1	FUEL QUANTITY - AS 350 MODELS
			1		D3997-3	JCA-M47-P2	FUEL QUANTITY - EC 130 B4 MODEL
	1		1		D3997-5	JCA-M47-P3	AUX FUEL DRAIN
	1		1		D3997-7	JCA-M47-P4	AUX FUEL TRANSFER PUMP
	1		1		D3997-9	JCA-M47-P5	AUX FUEL
	1		1		D3997-11	JCA-M47-P6	WEIGHT AND BALANCE
	1		1		D3997-13	JCA-M47-P7	ON/OFF
	1		1		D3997-15	JCA-M47-P8	CHECK LOCKER TANK
	1		1		D3997-17	JCA-M47-P9	STOWAGE PROHIBITED
	1		1		D3997-19	JCA-M47-P10	TANK VENT
	1		1		D3997-21	JCA-M47-P13	SWITCH FIXED
	1		1		D3997-23	JCA-M47-P14	AUX FUEL
	1				D3997-25	JCA-M47-P15	CONVERSION CHART - AS 350 MODELS
			1		D3997-27	JCA-M47-P16	CONVERSION CHART - EC 130 B4 MODEL
	1		1		D3997-29	JCA-M47-P17	DO NOT OVERFILL WARNING
	1		1		D3997-31	JCA-M47-P18	ON/OFF
	1		1		D3997-33	JCA-M47-P19	AUX GAUGE FACE
	1		1		D3997-35	JCA-M47-P20	AUX FUEL GAUGE
	1		1		D3997-37	JCA-M47-P21	6.3 A CIRCUIT BREAKER
	1		1		D3997-39	JCA-M47-P22	2.5A CIRCUIT BREAKER
	1		1		D3997-41	JCA-M47-P23	AUX TANK NOT FITTED
	1		1		D3997-43	JCA-M47-P24	EARTH